

Work Order ID 85616-1

SLIT

85616

Page 1

Item ID: D4095-041

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearplate Assembly *4*

Stop ***NS2***

Start Date: 12/06/2012 Start Qty: 12.00

12

Required Date: 26/06/2012 Req'd Qty: 12.00

12

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/12* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	B					<i>(12)</i>			
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							<i>B12-6-13</i>
FLOW CNC Waterjet	1-Cut as per Dwg (D4095-1)								
<i>304 . 063</i>	Dwg Rev: <i>B</i>								
	Prog Rev: <i>B</i>								
	2-Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							<i>B12-6-13</i>
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control						<i>(17)</i>			

5/12/06/115



Work Order ID 85616

June-12-12 8:50:27 AM

85616

Page 2

Item ID: D4095-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Assembly
Start Date: 12/06/2012 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 26/06/2012 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157	0.00 0.00				12			SPB 12/06/12
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg D4095	0.00 0.00		8/17/06/19		(42)			
150 *150* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch 1122210 Large Fab Memo	0.00 0.00				4			ABL 12-07-03

June-12-12 8:50:27 AM

Page 3

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER
DWG
A/R ROCKGUARD BATCH: 122212

Work Order ID 85616

June-12-12 8:50:27 AM

85616

Page 4

Item ID: D4095-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 12/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

4 12 02 04

200

Identify as per dwg & Stock Location: FP-1

0.00

200

Packaging

Memo

0.00

Packaging

4 12 07 04

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/7/5

MF
12-07-04

Picklist Print

June-12-12 8:50:30 AM

Page 1

Work Order ID: 85616

85616

Parent Item: D4095-041

D4095-041

Parent Item Name: Wearplate Assembly

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	38.5624	2.275	28.73684			

M304S16GA

**

B12-6-13

D4/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

38.562433

121626

3.1778

121889

35.384633

121889

(12)

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DART AEROSPACE LTD		Work Order:	25616
Description: Wearplate		Part Number:	D4095-1
Inspection Dwg: D4095	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

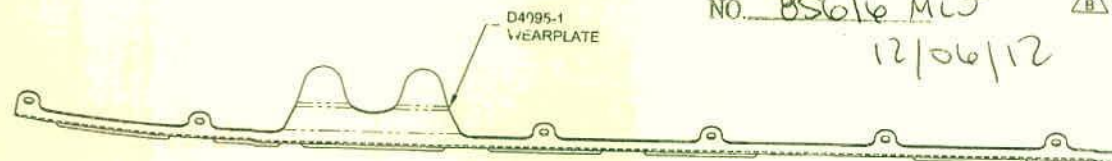
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.190	✓		V B2	
0.300	+/-0.010	.301	✓		V	
0.300	+/-0.010	.299	✓		V	
2.432	+/-0.010	2.438	✓		V	
3.227	+/-0.010	3.221	✓		V	
4.06	+/-0.030	4.053	✓		V	
4.98	+/-0.030	4.986	✓		V	
8.43	+/-0.030	8.424	✓		V	
9.22	+/-0.030	9.22	✓		T B2	
3.500	+/-0.010	3.500	✓		T	
24.750	+/-0.010	24.750	✓		T	
11.50	+/-0.030	11.50	✓		T	
11.472	+/-0.010	11.472	✓		T	
6.000	+/-0.010	6.000	✓		T	
12.104	+/-0.010	12.104	✓		T	
18.000	+/-0.010	18.000	✓		T	
30.000	+/-0.010	30.000	✓		T	
9.00	+/-0.030	9.00	✓		T	
36.000	+/-0.010	36.00	✓		T	
38.87	+/-0.030	38.87	✓		T	
2.50	+/-0.030	2.503	✓		T	
0.063	+/-0.010	.057	✓		V	

Measured by: B	Audited by: S	Preliminary Approval:
Date: 12-6-13	Date: 12/6/15	Date:

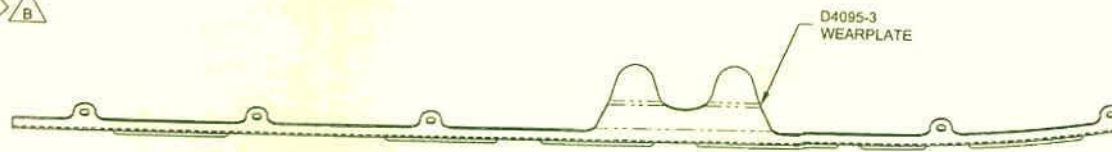
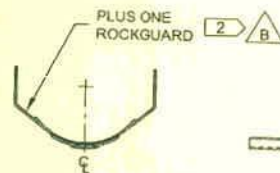
Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-041	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85616 MLJ
12/06/12

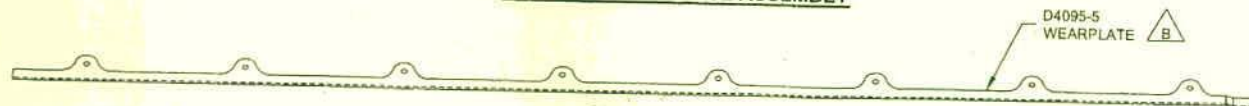
ITEM	QTY	QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X							D4095-041	WEARPLATE ASSEMBLY
2		X						D4095-043	WEARPLATE ASSEMBLY
3			X					D4095-045	WEARPLATE ASSEMBLY
4				X				D4095-047	WEARPAD ASSEMBLY
5					X			D4095-049	WEARPAD ASSEMBLY
6						X		D4095-051	WEARPAD ASSEMBLY
7	1							D4095-1	WEARPLATE
8	1							D4095-3	WEARPLATE
9		1						D4095-5	WEARPLATE
10			1					D4095-7	WEARPAD
11				1				D4095-9	WEARPAD
12					1			D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (FAN)



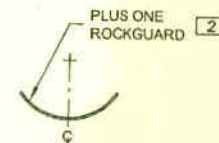
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY



D4095-041/-043/-045/-047/-049/-051 NOTES:

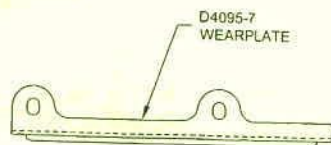
- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-11/1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4095-11/3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.16
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED	10		
MFG. APPR.	10		
APPROVED	10		
DE APPR.	10		
DATE	11.10.18		

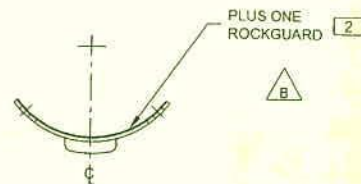
DART AEROSPACE USA, INC
KENT, WA

DRAWING NO. D4095
TITLE WEARPLATE
REV. B
SHEET 1 OF 8
SCALE
NTS

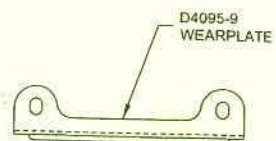
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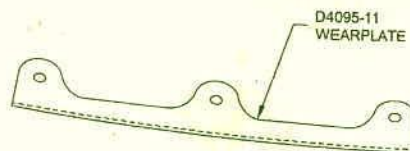
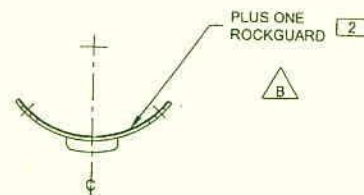
D4095-047 WEAR PAD ASSEMBLY



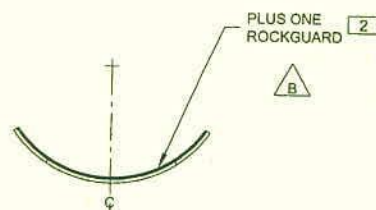
85614



D4095-049 WEAR PAD ASSEMBLY

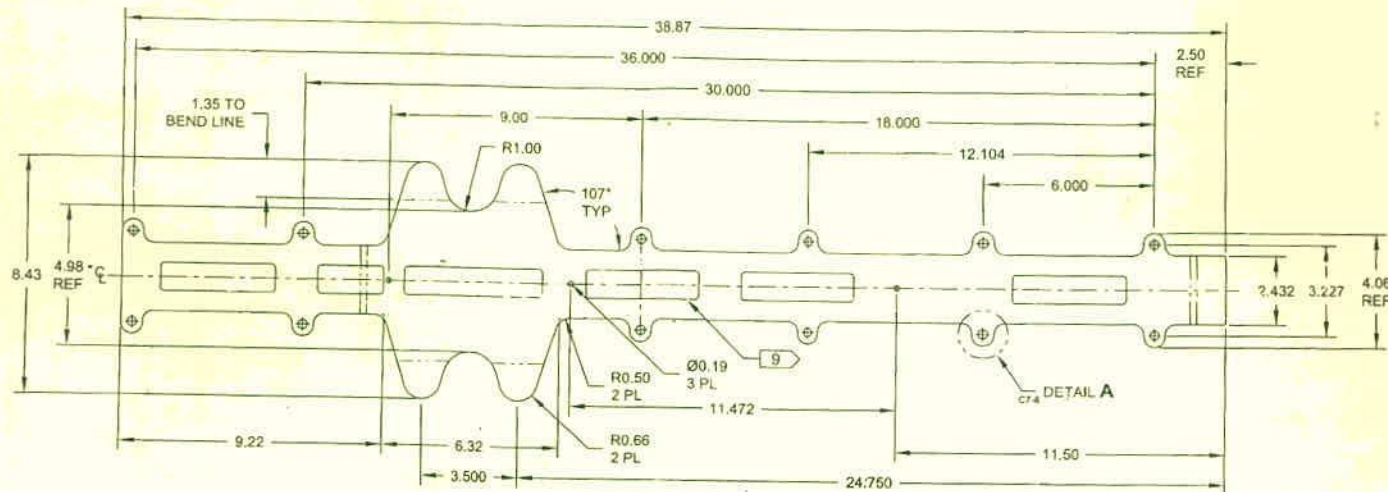


D4095-051 WEARPAD ASSEMBLY

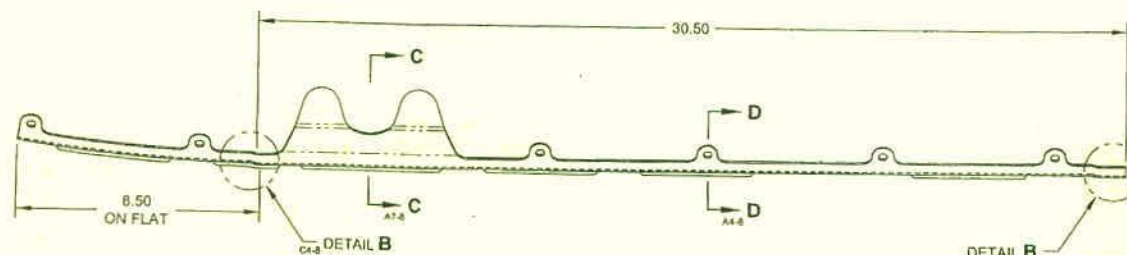


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MFG. APPR.	140	D4095	SHEET 2 OF 6
APPROVED	140	TITLE	SCALE
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D4095-1F FLAT PATTERN



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1/-1F/-3/-3F/-5/-5F/-7/-7F/-9/-9F/-11/-11F NOTES:

1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX

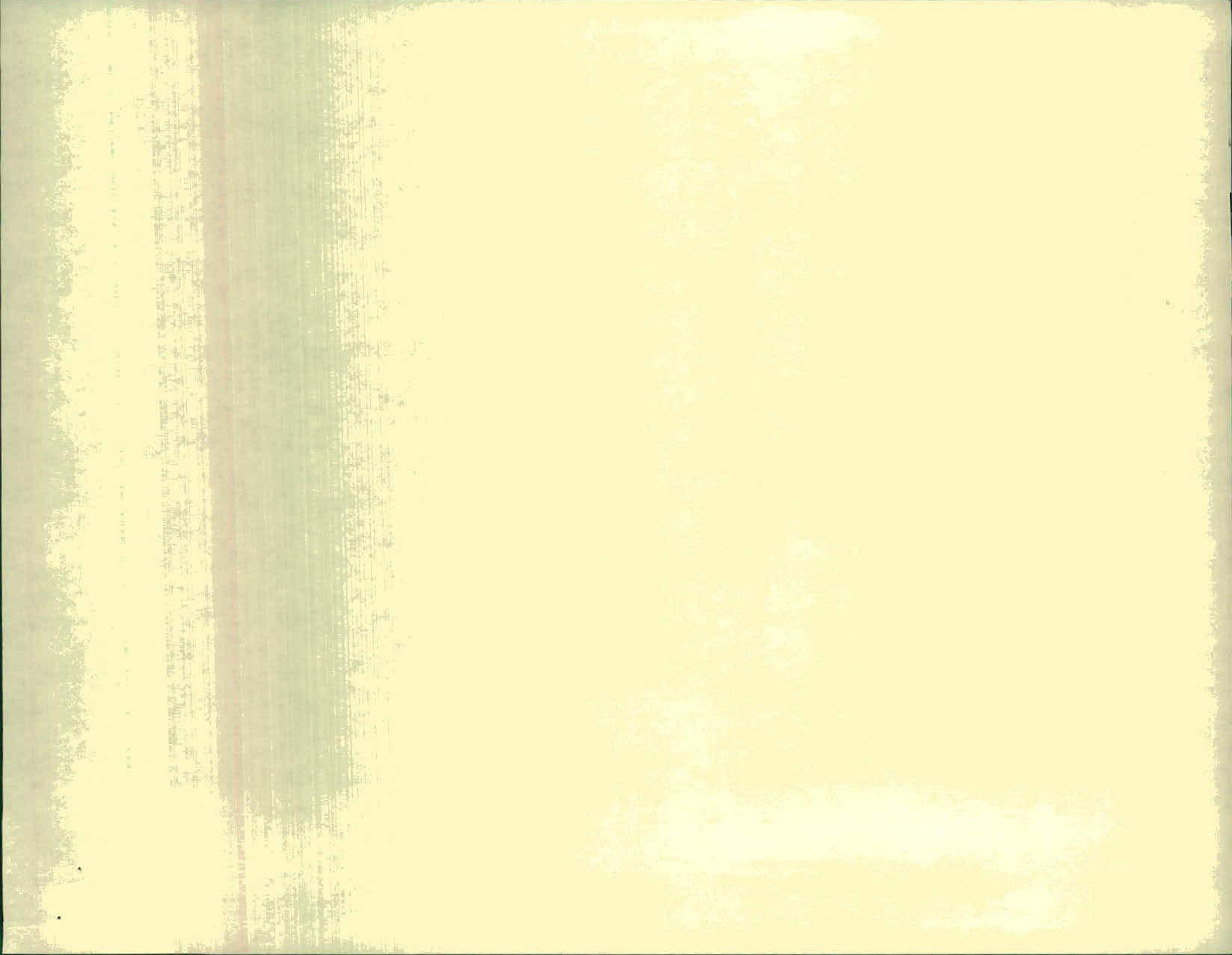
6) IDENTIFICATION: N/A

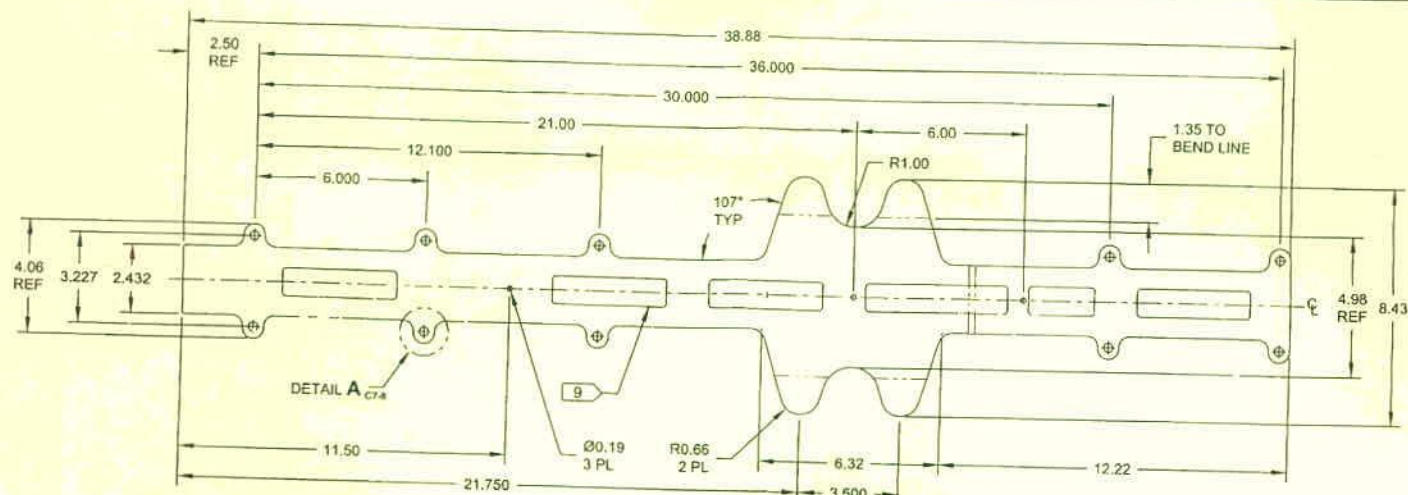
7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.38 lbs

8) WELDING: PER DART QSI 004

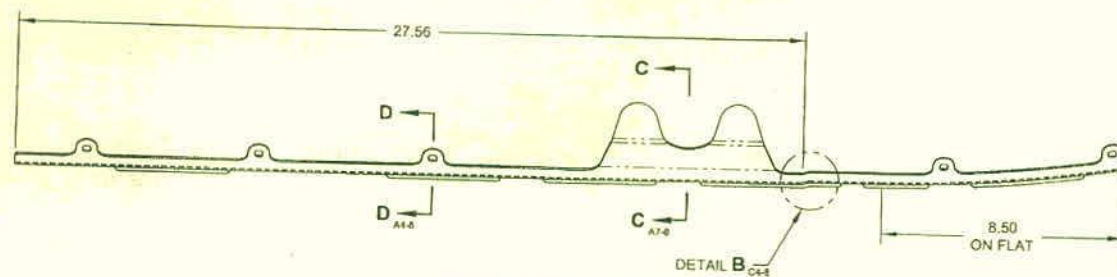
9) PARTS ARE SYMMETRIC ABOUT ϕ

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D4095-3F FLAT PATTERN 1

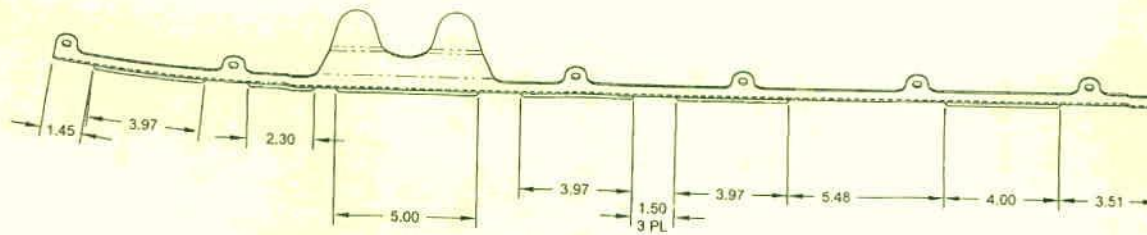


D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

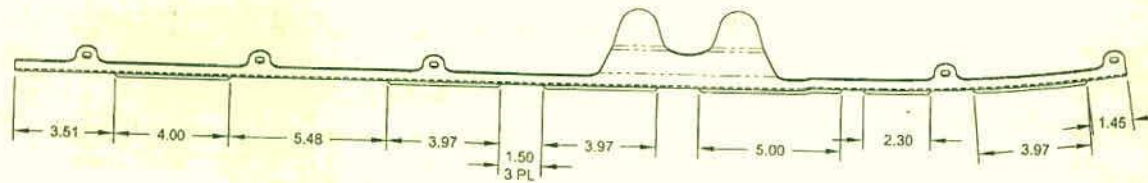
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85614



D4095-1 WELDING DETAIL

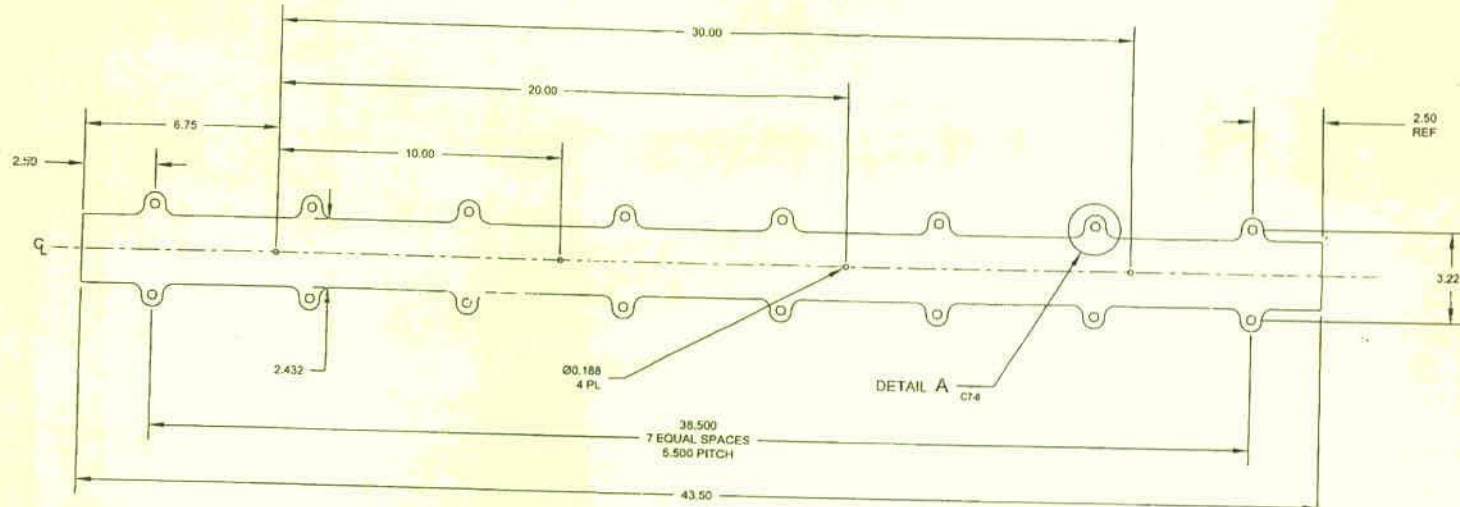


D4095-3 WELDING DETAIL

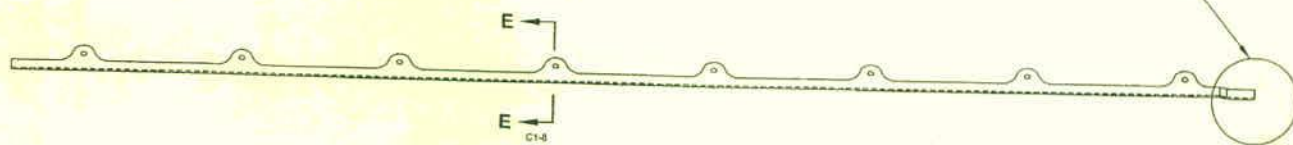


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D4095-SF FLAT PATTERN

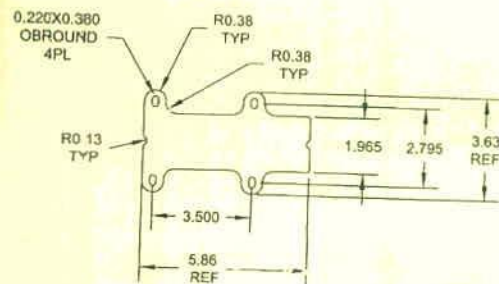


D4095-S BENDING DETAIL
(MAKE FROM D4095-SF)

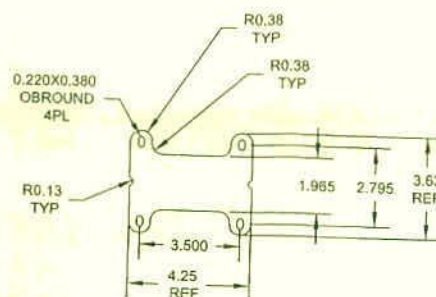
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CHECKED	10	DRAWING NO.	REV. B
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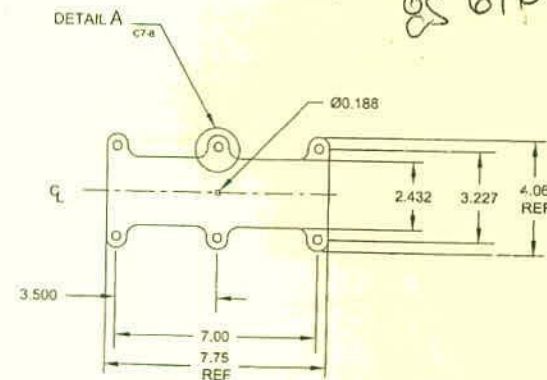




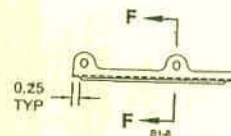
D4095-7F FLAT PATTERN



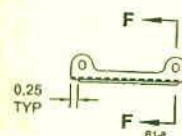
D4095-9F FLAT PATTERN



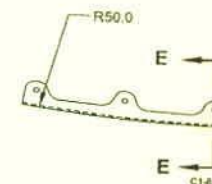
D4095-11F FLAT PATTERN



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)

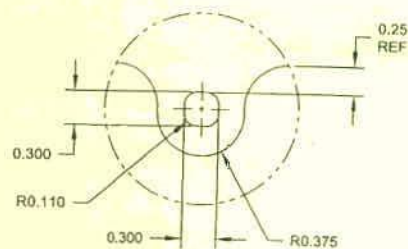


D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

DESIGN	XDF	DART AEROSPACE USA, INC
DRAWN	140	KENT, WA
CHECKED	140	DRAWING NO. REV. B
MFG, APPR.	140	D4095 SHEET 7 OF 8
APPROVED	140	TITLE SCALE
DE APPR.	140	WEARPLATE NTS
DATE	11.10.18	COPYRIGHT © 2018 BY DART AEROSPACE USA, INC

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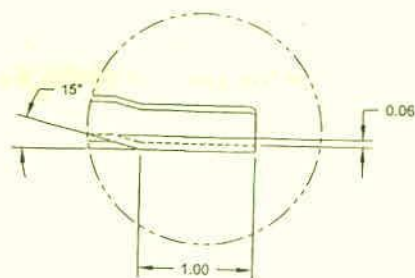




DETAIL A: TAB DETAIL

SCALE 4X

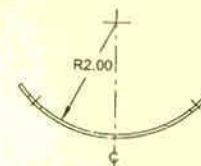
C3-3
C6-4
D2-6
D2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

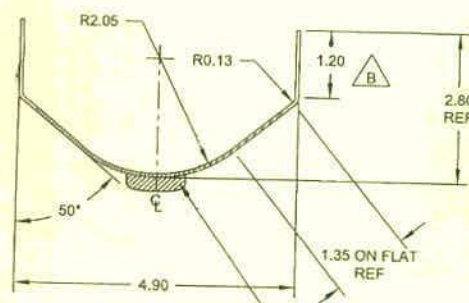
B2-3
B6-3
B3-4
B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

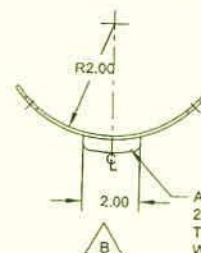


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

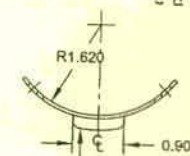


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4095	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	NTS
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